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RBE703A95-0520-01
Job Sheet 191095



Part No: RBE703A95-0520-01

Job Qty: 4 pcs

Part Name: Engine And Hydraulic Drain Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: Stock

Description: Rev J SAD

Note: URF 19-600, URF 19-561 DWG RBE703A95-0520-01 Rev 4 IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	3/29/19		1.00	0.27	Small Fab - 1		DAS 71 9-89 19-4-15
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	3/29/19		0.00	0.00	QC 5 - 10		DAS 40 9-89 APR 15 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	4 pcs	3/29/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		

Plex 2/21/19 11:12 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				140 QC 21 - FG	4 pcs	3/29/19	0.00 0.00	QC 21 - FG - 21	
								QC 21 - FG - 70	APR 17 2019
								QC 21 - SA - 53	

DAS
70
9-89

Part Op 100 - 1-Assemble -9 coupling with -7 hose. 2-Bag and tag. Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel Descriptions: into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

110 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____), Identify and Stock

140 - (QC21- Final Inspection - Work Order Release)

4x -17
4x -19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
51495K116	COUPLING 1/2" NCKL PLTD BRASS	4 Ea (1 ea)	100-Small Fab - 1	5157271
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	24 ft (6 ea)	100-Small Fab - 1	5159561
M304TR0.375W.065	304 Round Tube .375 X .065W	.3320 ft (.083 ea)	100-Small Fab - 1	5145223
RBE703A95-0520-01-1	Quill	4 pcs (1 ea)	100-Small Fab - 1	5158394

GA044
GA137A
MAT018
GA133

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	51495K116	4	52	0
	K010-0608	24	275	0
	M304TR0.375W.065	0	57	0
	RBE703A95-0520-01-1	4	0	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

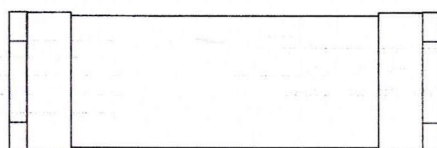
NCR No. _____

Route update only ☐

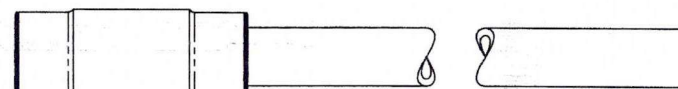
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
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Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY Other/Details: _____			

ITEM #	QTY	PART #	PART TITLE
-17	1	RBE703A95-0520-01-17	ENGINE & HYDRAULIC DRAIN TUBE QUILL ASSEMBLY
-19	1	RBE703A95-0520-01-19	ENGINE & HYDRAULIC DRAIN TUBE HOSE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191095 MJS
1903-06



-17



-19

RBE703A95-0520-01 ENGINE & HYDRAULIC DRAIN TUBE

8

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) PLACE ITEM -19 COILED INTO A TIGHT FITTING SEALED PLASTIC BAG WITH ITEM -17

SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED ITEMS -17, -18, -19, AND 23 ITEM 22 WAS MCMASTER-CARR #91585A030 IS McMaster#93600A252 OR EQUIV. -1 DIM WAS Ø0.0983/0.0979 IS Ø0.0984+0/-0.0008. REMOVED FLATS FOR ENGRAVING S/N, T/N, AND "MADE IN USA". ADDED NEW FLAT FOR ENGRAVING T/N		19-561	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT	TOOL PART # RBE703A95-0520-01	
CHECKED	MBB	REV. J SHEET 1 OF 7	
MFG. APPR.	DP	TITLE ENGINE & HYDRAULIC DRAIN TUBE	
APPROVED	WP	SCALE NTS	
DATE 2/25/2019		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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Container No: S172520



Part: RBE703A95-0520-01

Job No: 191095

Serial No/Batch: S172520

Revision: J

Inspector:

Exp Date:

Instructions:

Date: 04/15/19